

Date: Tuesday, 12/11/2007 8:16:21 AM
 User: COSS Admin

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TUBE
Job Number : 36247	
Estimate Number : 12773	
P.O. Number : <i>N/A</i>	Part Number : 41232 200 002 001
This Issue : 12/11/2007 S.O. No. : <i>N/A</i>	Drawing Number : 41232-200-002 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i>	Drawing Revision : A
Previous Run : 31776	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 12/18/2007
Checked & Approved By : <i>[Signature]</i>	Qty: <i>4</i> Um: Each
Comment : Est Rev A New Issue 07-03-05 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3H1375	2024-T3 Hex Bar 1.375"
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Comment: Qty.: 0.4550 f(s)/Unit Total : 2.7298 f(s)

2024-T3 Hex Bar 1.375"

Batch: *M103753*

DSP 07/12/11

2.0	LATHE CONV.	CONVENTIONAL LATHE
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Comment: CONVENTIONAL LATHE

Turn as per Dwg 41232-200-0021

TURN BORE TAP DRILL 45/64" AND TAP 3/4"20

DSP 07/12/11



3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DSP 07/12/11



4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA687 Rev. *A* & Dwg 41232-200-002 Rev. *A*

2-Deburr

SA 07.12.17



5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 07.12.17



Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 36247

Part Number: 41232 200 002 001

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

Handwritten: 07-12-13 (4)

7.0

OUTSIDE SERV.30

OUTSIDE SERVICES-MACH



Comment: Sub-Contracting PURCHASING

Issue P/O: 5359

Black Anodize as per Dwg 41232-200-005

Ensure Certificate of Conformity is attached

Handwritten: 08/01/04 (4)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

Handwritten: 08/01/14 (4)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: 08/01/14 (x4)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST394

Handwritten: 08/01/15 (x4)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



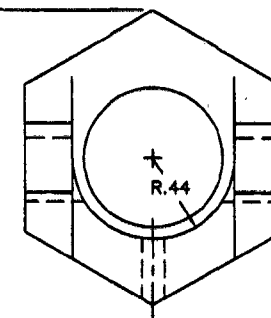
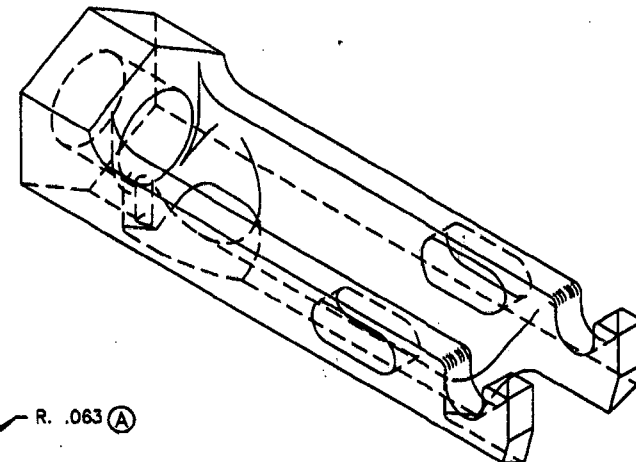
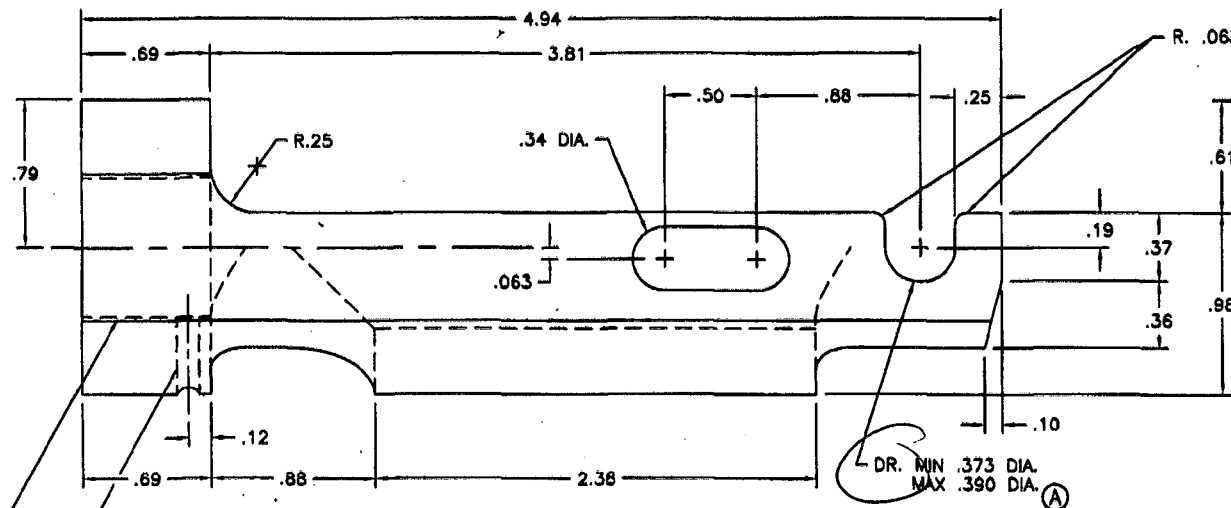
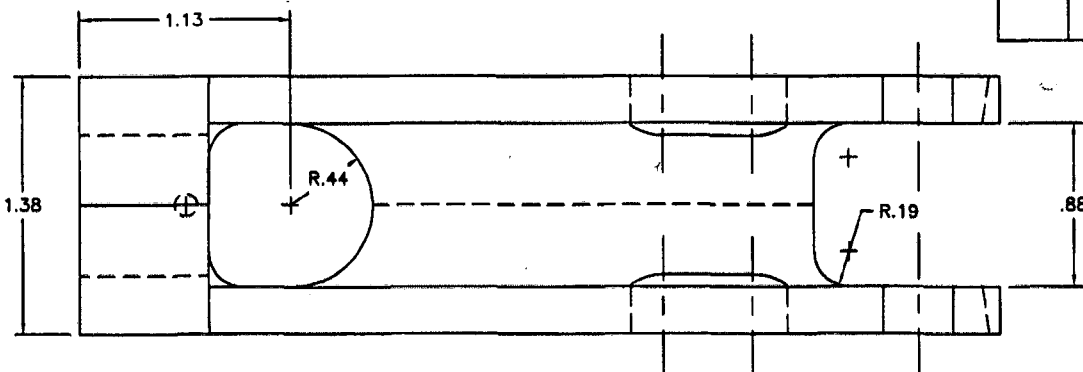
Comment: FINAL INSPECTION/W/O RELEASE

Handwritten: 08/01/16 (4)

Job Completion



Handwritten: 08-01-15



DR. .12 DIA. DRAIN HOLE
(NOTE: SPOTFACE IF REQ'D TO DRILL HOLE) (A)

3/4"-20 THD.

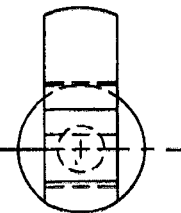
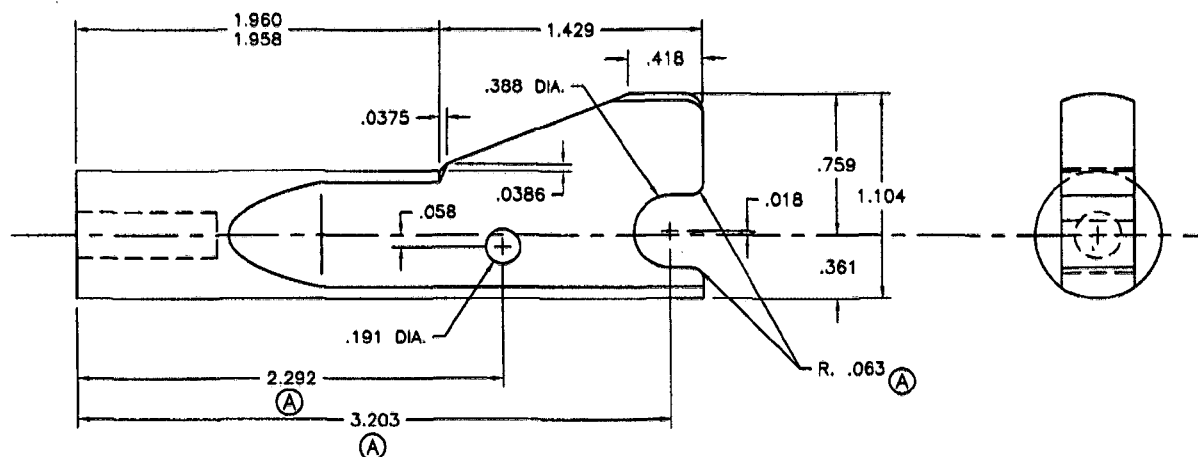
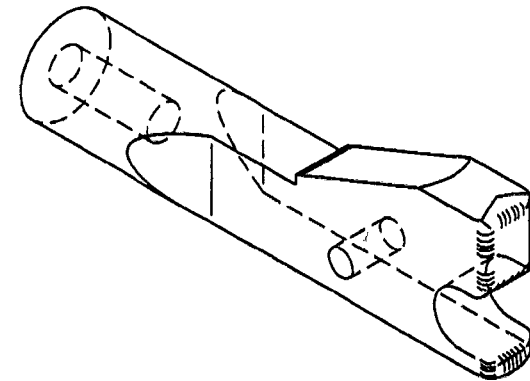
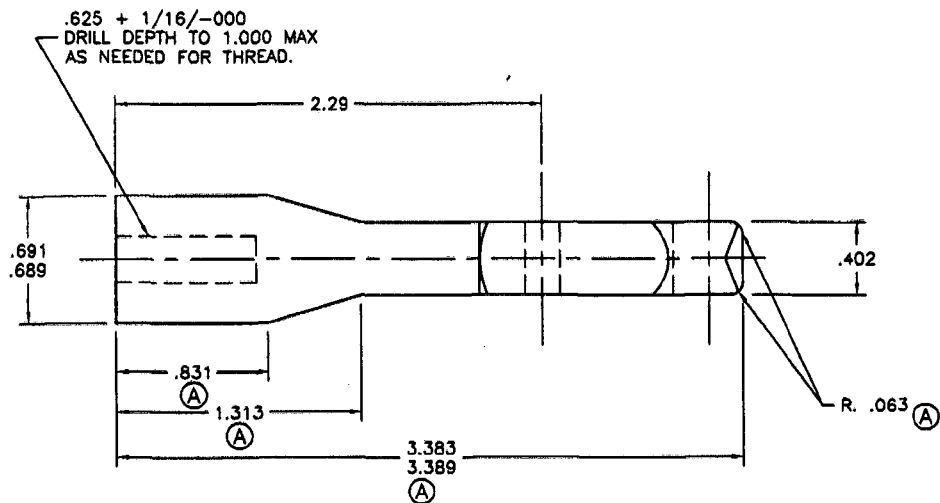
-001 TUBE

⚠ ANODIZE IN ACCORDANCE WITH MIL-A-8625, TYPE III, CLASS 2 DYED BLACK.

NOTE:

REVISION			
LETTER	DFTSMAN	DATE	DESCRIPTION
A	DNN	2/17/03	ADDED SMOOTH EDGES TO -001 & -003; REDUCED LENGTH OF -003 BY .125"; ADDED DRAIN HOLE TO -001; INCREASED DIA. OF AFT SLOT ON -001.
MINOR CHANGE - FAR 21.95 CHECK D. MURPHY 2/17/03			

1	MS21209F4-15	INSERT			
	-005	PIVOT ARM	⚠	1.00 DIA. x 3.56	2024-T4, T351 ALUM.
	-003	LATCH	⚠	1.11 x 3.50	2024-T4, T351 ALUM.
	-001	TUBE	⚠	1.38 HEX STK. x 4.94	2024-T4, T351 ALUM.
	-005	PART NO.	NAME	STOCK SIZE	MATERIAL
NO. REQ'D PER ASSY					
LIST OF MATERIAL					
PROPRIETARY RIGHTS NOTICE		UNLESS OTHERWISE SPECIFIED		TITLE	
THESE DATA ARE PROPRIETARY TO ERA ANOTON, INC. NO REPRODUCTION, OR USE OF THESE DATA FOR ANY PURPOSE IS FORBIDDEN WITHOUT WRITTEN APPROVAL FROM ERA ANOTON, INC. THE FORBIDDANCE DOES NOT APPLY TO VENDOR PARTS.		DRAFTSMAN D. NELSON 2/18/02		STEP ACTUATOR COMPONENTS	
		CHECK D. MURPHY 2/18/02			
		STRESS		DWA. SIZE C	
		PROD. ENGR.		SCALE 2:1	
		HEAT TREAT		DWA. NO. 41232-200-002	
		FRESH		SHT 1 OF 3	
		ERA ANOTON, Inc.		REV. A	
2 41232-200-001		NEXT ASSEMBLY			



-003 LATCH

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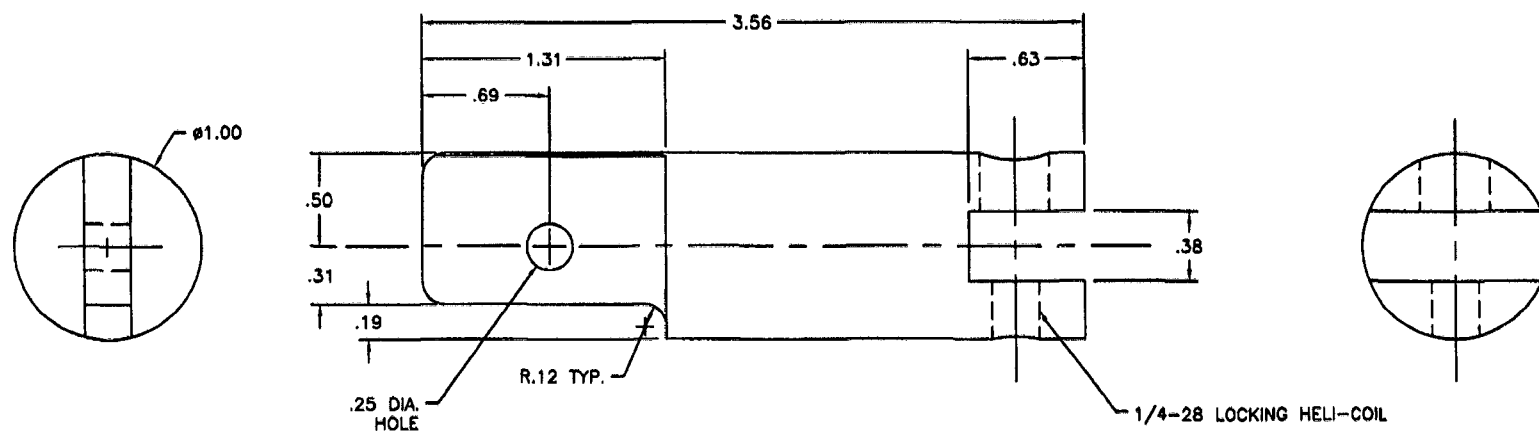
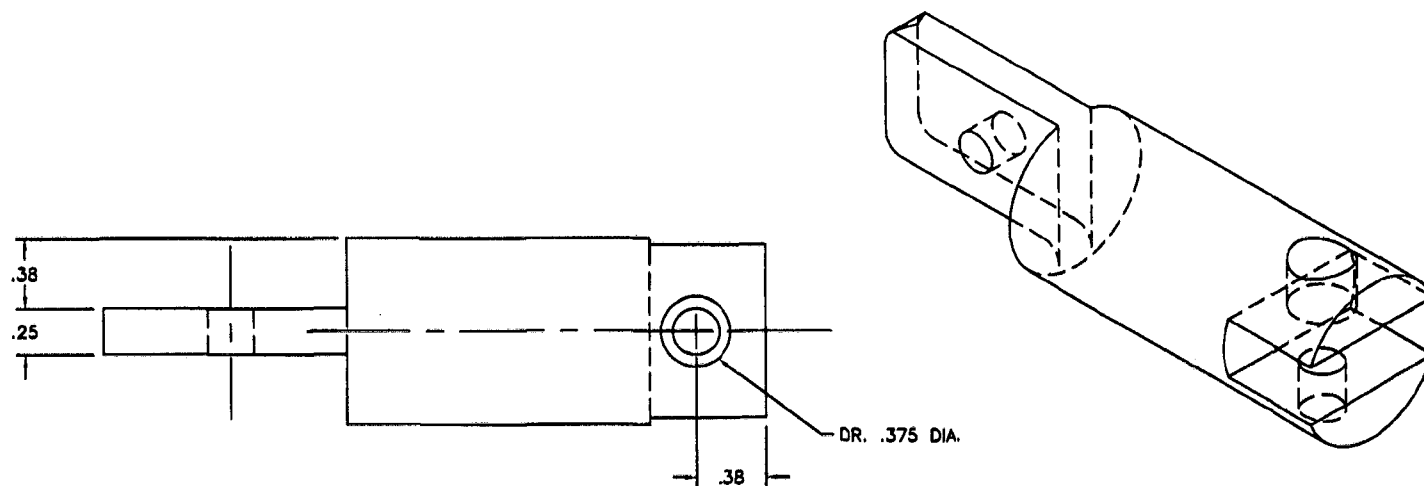
Era Aviation, Inc.

TITLE
STEP ACTUATOR COMPONENTS

SIZE
C

DWG. NO.
41232-200-002
SHT 2 OF 3

REV.
A



-005 PIVOT ARM

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 GOING DOES NOT APPLY TO VENDOR PARTS.

Era Aviation, Inc.

TITLE
 STEP ACTUATOR COMPONENTS

SIZE
 C

DWG. NO.
 41232-200-002
 SHT 3 OF 3

REV.
 A

DATE 2/26/04	ENGINEERING ORDER	E.O. No. B-1	SHT. 1 OF 1
BY D. NELSON		DWG. AFFECTED 41232-200-002	
APPROVED BY		SHEET AFFECTED SHT 1 & 3	
TITLE STEP ACTUATOR COMPONENTS			

REASON FOR CHANGE: CHANGED DASH NO. OF INSERT ON L/M; CHANGED INSERT CALLOUT ON -005 PIVOT ARM.

MINOR CHANGE - FAR 21.95

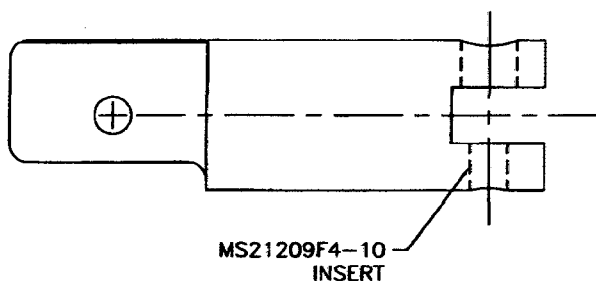
IS

1	MS21209F4-10	INSERT
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WAS

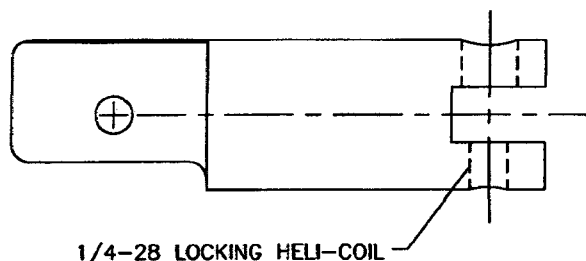
1	MS21209F4-15	INSERT
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IS



-005 PIVOT ARM

WAS



-005 PIVOT ARM

CHANGE REQUIRED:	DATE:	BY:	YES	NO
TRAVELER				
INSTALLATION INSTRUCTIONS				
MAINTENANCE INSTRUCTIONS				
ILLUSTRATED PARTS				
UNINCORPORATED DRAWING LIST				
MASTER DRAWING LIST				
COMPUTER DATA BASE				

DART AEROSPACE LTD		Work Order:
Description:		Part Number:
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.94	$\pm .030$	4.920	/			
.69	$\pm .030$.691	/			
R.25		R.25	/			
Ø.34		Ø.340	/			
.50	$\pm .030$.500	/			
.44	$\pm .030$.416	/			Calculated dimension
Ø.373-.390	N/A	Ø.373	/			
.19	$\pm .030$.19	/			
.37	$\pm .030$.37	/			
.36	$\pm .030$.362	/			
.98	$\pm .030$.969	/			
.61	$\pm .030$.623	/			
2.38	$\pm .030$	2.381	/			
.88	$\pm .030$.878	/			
.12	$\pm .030$.126	/			
Ø.12		Ø.125	/			
.88	$\pm .030$.879	/			
1.13	$\pm .030$	1.130	/			

Measured by:	SA
Date:	01.12.17

Audited by:	
Date:	

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

3685

1865

TNM.**ANODISATION et PEINTURE TNM INC.**

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001:2000 / AS9100 certified

approuvé NADCAP approved

61292

11-Jan-2008

CLIENT / CUSTOMER:**DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY, ONTARIO

K6A 1K7

**CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE****PURCHASE ORDER/**
NO. DE COMMANDE: 5359

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	4	4	41232 200002 001 B36 47	PER DWG: 41230-200-005 BLACK ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER
2	4	4	41232 200002 003 B35 03	PER DWG: 41230-200-005 BLACK ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER

REQUIREMENTS HAVE BEEN IN ACCORDANCE WITH MID-INC P.R.I.D.E. MANUAL

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.

Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"**NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.**

Signature /Signed:

Directeur de la Qualité / Q.A. Manager



DART

Purchase Order

Date Jan 04, 2008	Page 1
Purchase Order Number PO00005359	

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

FAKED
65 01109

Vendor Address:

Anodizing & Paint T.N.M. Inc.
21 Aviation Road
Pointe Claire, QC H9R 4Z2
Phone (514) 429-7777
Fax (514) 429-5108

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		V-AND002	Jan 04, 2008	N30	Purolator	Jan 11, 2008

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
4.0000	41232 200 002 001 B	BLACK ANODIZE Comments: BLACK ANODIZE AS PER DWG D41232-200-005	1/11/2008	No	11.250000		45.00
4.0000	41232 200 002 003 B	BLACK ANODIZE Comments: AS ABOVE	1/11/2008	No	11.250000		45.00

CL 08/01/14

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

Comments:

Tax Summary:
GST
GSTME
GSTND

4.50
0.00
0.00

Less:
included tax

0.00

Subtotal

90.00

Total tax

4.50

Total purchase order in

CAD Dollars

94.50

Entered By CL CLAVOIE

Approved By: W